

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018216**Date Inspected:** 17-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girders**Summary of Items Observed:**

At the start of the shift the Quality Assurance Inspector (QAI) traveled to the project site and observed the following work performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below:

- A). Field Splice E6/E7
- B). Ventilation Access Hole, Longitudinal Stiffeners
- C). Pipe Supports

- A). Field Splice E6/E7

The QAI observed the welder, Hua Qiang Hwang ID-2930, performed the CJP groove welding on the "B" face of the longitudinal stiffener field splice identified as WN: 6E-7E-A-LS2. The welder utilized the SMAW process as per the Welding Procedure Specification (WPS) identified as ABF-WPS-D15-1012-3, Rev.0 and was also utilized by the QC inspector John Pagliero as a reference. The amperage was recorded as 121 amps and the minimum preheat of 100 degrees Celsius and the maximum interpass temperature of 230 degrees Celsius was verified. The preheat temperature was maintained utilizing the heat induction process. The CJP welding was completed during this shift.

The welding of the longitudinal stiffener field splice was performed in the vertical (3G) position with the work placed in an approximately vertical plane and the groove approximately vertical. The welder utilized a slag hammer, pneumatic air gun with an attached chisel and a wire wheel attached to a 4" high cycle grinder to remove slag after deposit of each fill pass. The electrodes were stored in electrically heated, thermostatically controlled

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oven after removal from sealed containers. The exposure limits of the electrodes identified as E9018-H4R and the minimum storage oven temperature of 250 degrees Celsius appeared to be in compliance with the contract documents. At the time of the observation no issues were noted by the QAI.

The QAI also observed the excavation of the UT repair identified as WN: 6E-7E-F1,R2. The excavation was machined to a bright metal by the welder Jorge Lopez ID-6149 utilizing a high cycle grinder to remove the defect and a rotary file to bring the excavated area into compliance with the Weld Procedure Specification (WPS) ABF-WPS-D15-1001 Repair, Rev. 0. At the conclusion of the excavation the QC inspector, William Sherwood, performed a visual inspection and a Magnetic Particle Test (MPT) of the areas and no rejectable indications were noted by the QC inspector. At this time the welder commenced the repair welding utilizing the Shielded Metal Arc Welding (SMAW) process as per the WPS which was also utilized by the QC inspector to monitor the welding and to verify the DC welding parameters. The QC inspector verified the DC welding parameters as 115 amps and the minimum preheat temperature 40 degrees Celsius and the maximum interpass temperature of 230 degrees Celsius which appeared to comply with the contract documents. Prior to the welding the QAI verified the dimensions of the excavation and were noted and recorded as follows; Y=1010 mm, L=130 mm and d=10 mm. The welding and the QC inspection were completed during this shift.

B). Ventilation Access Holes, Longitudinal Stiffener

The QAI observed the welder Xiao Jian Wan ID-9677 perform the welding on the Complete Joint Penetration (CJP) groove joint identified as 3E-PP23.5-E5-West on the "A" deck of the Orthotropic Box Girder (OBG) E4. The welding was performed utilizing the Shielded Metal Arc Welding (SMAW) process as per the WPS identified as ABF-WPS-D15-1012, Rev. 0 which was also used by the QC inspector John Pagliero as a reference to monitor and to verify the welding parameters which were observed and verified by the QAI as 124 amps. The welding was performed in the vertical (3G) position with the work placed in an approximate vertical plane with the groove approximately vertical with the weld progression up utilizing the 3.2 mm electrode. The groove joint appeared to comply with the AWS joint designation identified as B-U2a and the minimum preheat temperature of 100 degrees Celsius and the maximum interpass temperature of 230 degrees Celsius were verified by the QC inspector.

The welding of the longitudinal stiffener field splice was performed in the vertical (3G) position with the work placed in an approximately vertical plane and the groove approximately vertical. The welder utilized a slag hammer, pneumatic air gun with an attached chisel and a wire wheel attached to a 4" high cycle grinder to remove slag after deposit of each fill pass. The electrodes were stored in electrically heated, thermostatically controlled oven after removal from sealed containers. The exposure limits of the electrodes identified as E9018-H4R and the minimum storage oven temperature of 250 degrees Celsius appeared to be in compliance with the contract documents. At the time of the observation no issues were noted by the QAI.

The QAI also verified, at the request of the QC inspector, John Pagliero, the fit-up and alignment of the field splice identified as WN: 6E-PP37.5-E2-TS-North. At the conclusion of verifying the fit-up and the vertical alignment no issues were noted by the QAI. Later in the shift the QAI observed the welding of the transverse stiffener, performed by Wai Kitlai ID-2953, utilizing the E7018 H4R, 3.2 mm diameter electrode as per the Welding Procedure Specification (WPS) ABF-WPS-D15-1010, Rev. 1. The WPS was also utilized by the QC inspector John Pagliero as a reference to monitor and to verify the welding parameters which were observed and verified by the QAI as 112 amps. The welding was performed in the vertical (3G) position with the work placed in an

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approximate vertical plane with the groove approximately vertical with the weld progression up utilizing the 3.2 mm electrode. The groove joint appeared to comply with the AWS joint designation identified as B-U2a and the minimum preheat temperature of 60 degrees Celsius and the maximum interpass temperature of 230 degrees Celsius were verified by the QC inspector.

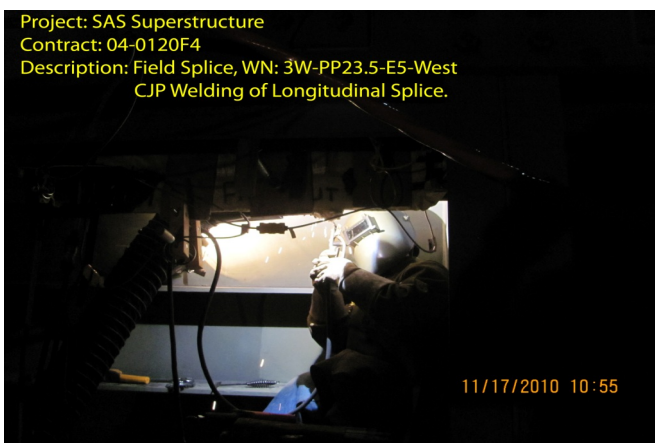
D). Pipe Supports

The QAI observed F.W. Spencer personnel installing and fillet welding the pipe supports identified as weld 101116-01, 101116-02, 101116-03 and 101116-04 to the embeds located at the W2 bent cap. The tack welding and field welding was performed by David Garcia ID-8789 utilizing a 3.2 mm electrode as per the Welding Procedure Specification (WPS) identified as Fillet Murex. The fillet welding was performed in various positions utilizing a 3.2 mm electrode. The QC inspection was performed by Mike Johnson utilizing the WPS to monitor the welding and to verify the amperage. The welding and inspection of the pipe supports was completed during this shift and at the request of the QC inspector the QAI verified the welding for contract compliance and no issues were noted by the QAI.

QA Observation and Verification Summary

The QA inspector observed the QC activities and the welding of the field splices utilizing the WPS as noted above, which appeared to be posted at the weld station. The welding parameters and surface temperatures were verified by the QC inspector and utilizing a Fluke 337 clamp meter for the electrical welding parameters and a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. The ESAB consumables utilized for the SMAW welding process appeared to comply with the AWS Specification and AWS Classification. The QC inspection, testing and welding performed on this shift appeared to be in general compliance with the contract documents. At random intervals, the QAI verified the QC inspection, testing, welding parameters and the surface temperatures utilizing various inspection equipment and gages which included a Fluke 337 Clamp Meter and Tempilstik Temperature indicators.

The digital photographs below illustrate the work observed during this scheduled shift.



Summary of Conversations:

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There were general conversations with Quality Control Inspector Bonifacio Daquinag, Jr. at the start of the shift regarding the location of American Bridge/Fluor welding, inspection and N.D.E. testing personnel scheduled for this shift.

In regards to the QAI verification, the QAI and QC inspector, Mike Johnson, agreed that QC would notify the QAI in a timely manner, either verbal or cell phone, to schedule weld inspection of the pipe supports. The QAI reminded Mr. Johnson that in the case the QAI had prior commitments or was involved with other inspections, that QC was to proceed with the scheduled work as not to burden the contractor's work schedule.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
